

WHAT IS CLAIMED IS:

1. A method for assembling a torque limiting device having a damper mechanism to be mounted to a member on the engine side thereof, the torque limiting device having an input plate that is fixed to a frictional coupling portion on the outer
5 periphery of the input plate, an output member having an engagement hole that engages with an output shaft on the inner peripheral portion thereof, a damper that elastically couples the input plate and the output member in the circumferential direction, and a torque transmission controller that is mounted to the engine side member, grasps the frictional coupling portion between a pair of plates, and controls
10 transmitted torque, the method comprising the steps of:
a first step in which the output member and the torque transmission controller are centered with respect to each other and attached to each other, and the torque limiting device is then assembled; and
a second step in which the torque transmission controller and the engine side
15 member are centered with respect to each other, and the torque limiting device is attached to the engine side member via the torque transmission controller.
2. The method of assembling the torque limiting device having a damper mechanism according to claim 1, wherein the input plate, the output member, and the damper are assembled together as a damper disk device prior to the first step.
- 20 3. The method of assembling the torque limiting device having a damper mechanism according to claim 2, wherein the input plate and the output member are centered and assembled together when the damper disk device is assembled.
4. The method of assembling a torque limiting device having a damper mechanism disclosed in claim 3, wherein the torque transmission controller includes:
25 a ring-shaped cover member that is disposed on the outer peripheral side of the friction coupling portion and mounted to the engine side member;
a pair of ring-shaped plates that are arranged such that the frictional coupling portion is interposed therebetween on an inner peripheral side of the cover member;
and
30 a biasing member for applying a predetermined grasping force to the pair of ring-shaped plates.

5. The method of assembling a torque limiting device having a damper mechanism disclosed in claim 4, wherein alignment holes are formed in the cover member along the axial direction; and

in the first step, a jig is used to center and assemble the torque limiting device, the jig having an axial portion that is inserted into an engagement hole of the output member, and alignment pins that are inserted into alignment holes of the cover member.

6. The method of assembling a torque limiting device having a damper mechanism disclosed in any of claims 3 to 5, wherein the input plate is a disk-shaped plate having holes in the inner peripheral portion thereof;

both ends of the output member in the axial direction are formed into a tubular shape, and one end thereof is inserted into a hole in the input plate; and a bush is provided between the outer peripheral surface of the output member and the inner peripheral surface of the input plate, and the output member and the input plate are centered with respect to each other.